

Date: Monday, 11/21/2005 7:40:54 PM
User: Linda Lacelle

Process Sheet

Split-2 2005.01.03

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 24862
Estimate Number : 10791
P.O. Number : N/A
This Issue : 11/21/2005 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : N/A
Written By : See comment below
Checked & Approved By : See comment below
Comment : Est Rev:B 05.09.23 Procedure change KJ/JLM

Drawing Name : FLOAT WEB
Part Number : D3282041
Drawing Number : D3282 REV C
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 12/20/2005
Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2792-130

Extrusion

B24030

Pm 05-11-28

Identify as D3282-1

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

Pm 05-11-28

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

ED 05/12/03 11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ED 05/12/03 11

PTD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 24862

Part Number: D3282041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 05/12/12 11

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

flm 05-12-13

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 05-12-16

8.0 D32831 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number
2 D3283-1

Description
Doubler

Batch

B25339

DP 05-12-16

3 (2)

9.0 MS20470AD47 Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 570.0000 Each(s)

Pick:

Qty Part Number
57 MS20470AD4-7

Description
Rivet

Batch

M11721

DP 05-12-16

PM 05-12-20

(2) 3

10.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 *417395*

DP 05-12-16

(2) 3

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-06-01-03 (2) 3

Monday, 11/21/2005 7:40:54 PM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 24862

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

DP00-1-3

(7) 3

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/05 3

RD 06/01/04 (3)

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Dart Aerospace Ltd.
Hawkesbury

Job Costing Report

Nov 17, 2005
03:30 pm

Work Order No : 0024862 -2
Project Name : D3282-041
Project For : WK550
Work Order Type : Main
Main WO Number :
House Part Number : D3282-041
Description : Float Web
Manufactured : Yes
Amount Req'd : 8.63
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

Labour Hrs/Amount Done :	Estimated	Actual
Profits/(Loss) :	0.00	0.00
	0.00	0.00